

Date: Monday, 6/25/2007 9:10:19 AM
User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	FLOOR WINDOW
Job Number :	33118		
Estimate Number :	10457		
P.O. Number :		Part Number :	D32121
This Issue :	6/25/2007 S.O. No. :	Drawing Number :	D3212 REV B
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	1 / Type : SMALL /MED FAB	Drawing Revision :	B
Previous Run :	32688	Material :	Multiples of 4
Written By :		Due Date :	7/10/2007
Checked & Approved By :	<i>JA 07.06.25</i>	Qty:	20 Um: Each
Comment :	Est Rev: A New Issue 05-11-09 JLM Est Rev: B Water jet/ ecn798 06-05-08 EC est rev.C back on haas 07.04.09 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MACRLICS125	1/8" Polycast II Sheet
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Comment: Qty.: 1.0232 sf(s)/Unit Total : 20.4645 sf(s)
Material: 0.125" Polycast Sheet
(M-ACRYLIC-S.125)
Identify as D3212-1
Batch: *11041596* *IB* *ml* *07 06 26*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
1-Cut blankas per Dwg D3212
Dwg Rev: *B*
Prog Rev: *B*
2-Deburr if necessary *IB* *ml* *07 06 26*

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Machine as per Folio FA349 and Dwg D3212

J.L 08/07/23

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 08/02/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 08/02/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 6/25/2007 9:10:19 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR WINDOW

Job Number: 33118

Part Number: D32121

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

8/08/02/24 (30)

6.0

D27281

Dart Logo label small



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Qty	Part #	Description	Batch
1	D2728-1	Dart Logo label	24215

AS 08/02/07 26 (X20)
SAP 08/02/07 10

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

- 1-Deburr if necessary
- 2-Install label as per Dwg D3212
- 3- polish abrasion scratches if necessary..
- 4-Wrap in plastic wrap after inspection

SAP 08/02/26 30

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-02-26 (30)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: 210

8/2/27 54 (30)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2008/02/07

Job Completion



08-02-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 33118
Description: Floor Window		Part Number: D3212-1
Inspection Dwg: D3212 Rev: B		Page 1 of 1

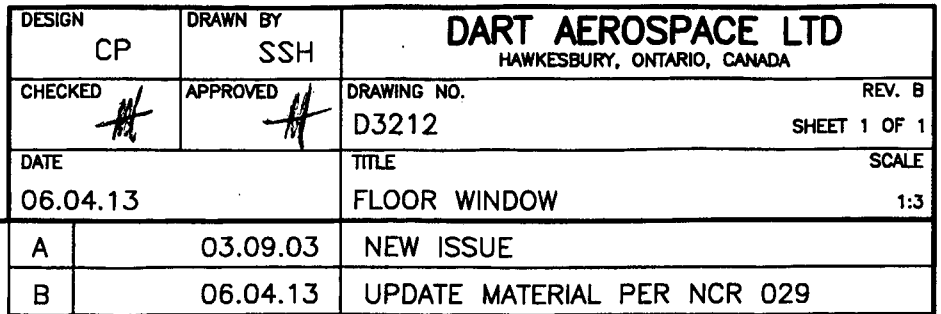
FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.734	+/-0.005	12.733	✓			
6.367	+/-0.005	6.367	✓			
0.625	+/-0.005	0.626	✓			
Ø0.156	+0.005/-0.001	0.157	✓			
R0.25	+/-0.030	0.25	✓			
8.150	+/-0.005	8.148	✓			
3.750	+/-0.005	3.748	✓			
0.313	+/-0.010	0.320	✓			
15.14	+/-0.030	15.155	✓			
12.520	+/-0.005	12.522	✓			
6.260	+/-0.005	6.259	✓			
1.312	+/-0.005	1.317	✓			
0.313	+/-0.010	0.322	✓			
3.750	+/-0.005	3.749	✓			
8.150	+/-0.005	8.151	✓			
8.462	+/-0.005	8.459	✓			
9.09	+/-0.030	9.100	✓			

Measured by: J.L.	Audited by: J. Dev. S.F.	Prototype Approval:	N/A
Date: 08/02/23	Date: 08-26	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.12.15	New Issue P/O D350-567-015/-025/-031	KJ/RF	
B	07.05.28	Dimensions updated per Dwg Rev. B	KJ/JLM	



33118

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